

Work Order ID 110476

\*110476\*

Page 1

December-20-13 9:17:57 AM

Item ID: D350-636-012 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 1.00 \*1\*

Required Date: 1/03/14 Req'd Qty: 1.00 \*1\*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: ML5 Date: 13-12-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

record fwd angle: 89°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

★  
SEE  
Attached  
Sheet.

14-1-27

Pho →


B110476RH

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: add Date: 14/03/17QA Closed: KH Date: 14-3-7

Work Order: <u>110476</u> Part No. <u>0350-634-012</u> NCR No. <u>14-3609</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%;"> <tr> <td>Skid-tube <input checked="" type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		14/1/27	100	1	Twist of forward bend is 85°. RC. Process/Tooling	DAS 12 9-89 14/1/27	Acceptable. Cosmetic only	DAS 12 9-89 14/1/27	 14-1-27	DAS 16 9-89 14/01/30
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process	X									
Supplier										
Training										
Unapproved										

## FAULT CATEGORY

Landing Gear	General	Other
<input checked="" type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

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Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

\*110\*

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

 14-1-27

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December-20-13 9:17:57 AM

Item ID: D350-636-012 Accept \*N900040100\* Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat. Stop \*NS2\*

Start Date: 12/20/13 Start Qty: 1.00 \*1\* Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 \*1\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: M127069 BE 14-01-28

12-Grind welds flush as per Dwg D2750

BE 14-01-28

120 QC10- Inspect visual per QSI004- ground welds 0.00

\*120\*

QC

Quality Control

Memo

0.00

① 14-01-28 DAS  
9  
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

\*130\*

QC

Quality Control

Memo

0.00

① 14-01-28 DAS  
9  
9-89

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## Quality Control

1 HB 14-1-28

141-1-28

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Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.  
 Start Date: 12/20/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/03/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes	<b>Memo</b>	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>M127097</u> exp. date: <u>11/02/16</u>			mm					14/01/29
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M127069</u>								BE 14-01-30
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								14-02-03 DGL

DGL 14-1-28

Pto

DQA:

Date:

17/03/13

QA Closed:

Date:

14-3-7

## WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>110474</u> Part No. <u>D350-436-012</u> NCR No. <u>14-3610</u>				<b>DISPOSITION</b> Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%;"> <tr> <td>Skid-tube Machining <input type="checkbox"/></td> <td>Crosstube Small Fab <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Rec/Store/Packaging Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube Machining <input type="checkbox"/>	Crosstube Small Fab <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging Supplier <input type="checkbox"/>	
Skid-tube Machining <input type="checkbox"/>	Crosstube Small Fab <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering Quality <input type="checkbox"/>																				
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Other <input type="checkbox"/>																				
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging Supplier <input type="checkbox"/>																					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector														
Design <input type="checkbox"/>	14/01/30	# 60,8	x1	11th hole from Aft. has the x-bolt spacer. Drilled out with a step on inside with Redrill RL Drills slipped in operator Hands.	DAS 16 9-89  052042 #15 14/01/30	Drill out + Rework 1st x-bolt spacer	BE 14-01-31	 14-2-3	DAS 16 9-89  052042 #15 14/01/30														
Doc/Data <input type="checkbox"/>						Re-weld as per 252042 D3490-1 B 109932 A/R M127069	BE 14-01-31																
Equip/Tooling <input type="checkbox"/>						grains welds Fls1	BE 14-01-31																
Handling/Pre <input type="checkbox"/>																							
Material <input type="checkbox"/>																							
Operator <input type="checkbox"/>																							
Offset/Setup <input type="checkbox"/>																							
Process <input type="checkbox"/>																							
Supplier <input type="checkbox"/>																							
Training <input type="checkbox"/>																							
Transport <input type="checkbox"/>																							
Unapproved <input type="checkbox"/>																							

## FAULT CATEGORY

## Landing Gear

- |   |
|---|
| <input type="checkbox"/> Bending                  |
| <input type="checkbox"/> Centre Not Concentric    |
| <input type="checkbox"/> Cracks                   |
| <input type="checkbox"/> Crimp/Kink/Ripple/Wave   |
| <input type="checkbox"/> Cuffs                    |
| <input type="checkbox"/> Crushing                 |
| <input type="checkbox"/> Heat Treat               |
| <input type="checkbox"/> Inspection Strip in Tube |
| <input type="checkbox"/> Marks/Chatter            |
| <input type="checkbox"/> Turning Sequence         |
| <input type="checkbox"/> Wave/Twist in Tube       |

## General

- |   |
|---|
| <input type="checkbox"/> Bend                 |
| <input type="checkbox"/> BOM/Route            |
| <input type="checkbox"/> Broken/Damage/Defect |
| <input type="checkbox"/> Burrs                |
| <input type="checkbox"/> Contamination        |
| <input type="checkbox"/> Countersink          |
| <input type="checkbox"/> Cut Too Short        |
| <input type="checkbox"/> Drawing              |
| <input type="checkbox"/> Drill Holes          |
| <input type="checkbox"/> Finish               |
| <input type="checkbox"/> Fit/Function         |

- |  |
|--|
| <input type="checkbox"/> Folio/Program                     |
| <input type="checkbox"/> Grain                             |
| <input type="checkbox"/> Hardware                          |
| <input type="checkbox"/> Inspection Incomplete/Unqualified |
| <input type="checkbox"/> Instructions Incomplete/Unclear   |
| <input type="checkbox"/> Misaligned/off center             |
| <input type="checkbox"/> Mislabeled                        |
| <input type="checkbox"/> Misread                           |
| <input type="checkbox"/> Off-set                           |
| <input type="checkbox"/> Out of Calibration                |
| <input type="checkbox"/> Out of Sequence                   |

- |   |
|---|
| <input type="checkbox"/> Outside Dimensions   |
| <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Part Incorrect       |
| <input type="checkbox"/> Part Lost/Missing    |
| <input type="checkbox"/> Part Moved           |
| <input type="checkbox"/> Positioned Wrong     |
| <input type="checkbox"/> Power Loss/Surge     |

- |   |
|---|
| <input type="checkbox"/> Pressure/Forced    |
| <input type="checkbox"/> Set-up             |
| <input type="checkbox"/> Temperature/Cure   |
| <input type="checkbox"/> Weld               |
| <input type="checkbox"/> Wrong Stock Pulled |
| <input type="checkbox"/> Other              |

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**\*1 10476\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Skidtube RH Aerazur / Apical Cylindrical Compat.

**Start Date:** 12/20/13      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 1/03/14      **Req'd Qty:** 1.00      **\*1\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

## 12-Deburr holes

14-1-3 DGL

170

QC10- Inspect visual per QSI004- ground welds	0.00
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**\*170\***

QC

## Memo

0.00

## Quality Control

14-01-14-02-04 DAS  
9  
989

180

QC5- Inspect part completeness to step on W/O	0.00
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**\*180\***

QC

## Memo

0.00

### Quality Control

\*\*\*VERIFY C'BOARD IS GOOD\*\*\*

1402.04



# Work Order ID 110476

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**\*110476\***

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Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.  
 Start Date: 12/20/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 1/03/14 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1		14-26	
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1	0	0	14-2-23
<b>*200*</b>									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>126543</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>128198</u>								
210	QC14- Inspect Spray Paint	0.00				1			14-2-24
<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

Work Order ID 110476

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Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
*230*	HandFinish	0.00							
Hand Finishing	<p>Memo</p> <p>1-Install inserts as per dwg D2750</p> <p>2-Inspect for Foreign Objects</p> <p>3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11127918</u> EXP DATE: <u>11/09</u></p> <p>4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11121651</u></p> <p>5-Coat all exposed fasteners with "LPS Procyon" batch: <u>11122900</u></p>								
240	QC5- Inspect part completeness to step on W/O	0.00							
*240*	QC	0.00							
Quality Control	Memo								

SKP  
11/2/26

1RH / 11/02/27

1

**Work Order ID 110476**

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**\*110476\***

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Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
<b>*250*</b>									
Packaging	Memo	0.00				1X	DAS 31 9-89	14-2-26	DAS 26 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
<b>*260*</b>									
QC	Memo	0.00	DAS 6 9-89	14-2-27					
Quality Control									
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00				1	8	14-03-05	
Packaging	Package as per PPP D350-636-012								

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

PL 14-03-4

PL 14-03-5

# Picklist Print

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

**Comments:** IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K  
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-  
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	5.0000	1	1			
<b>*D2600-3-BFNT*</b>									<b>**</b>				
Extrusion Bent													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	110478	5							
					109789	5							
D2744		Manufactured	No			110	Each	52.0000	1	1			
<b>*D2744*</b>									<b>**</b>				
Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001		52							
					100398	28							
					97543	24							
D2739		Manufactured	No			160	Each	11.0000	1	1			
<b>*D2739*</b>									<b>**</b>				
350 I Beam													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	110935	11							
					109712	1							
					109973	10							

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

331.0000

8

8

**\*D2743\***

Crossbolt Spacer

\*\*

BE140130

Location

Loc Qty

Loc Code

LG001

331

106245

9

107359

68

107907

122

109799

132

D3490-3

Manufactured No

160

Each

160.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE140130

Location

Loc Qty

Loc Code

LG001

160

103883

14

105603

3

107913

63

109933

80

D3490-1

Manufactured No

160

Each

225.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

\*\*

BE140130

Location

Loc Qty

Loc Code

LG001

225

107419

57

109932

168

D3631-1

Manufactured No

230

Each

12.0000

8

8

**\*D3631-1\***

Washer

\*\*

all 12/10/25

Location

Loc Qty

Loc Code

FP001

12

107324

12

B111556

✓8

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

3.0000

1

1

**\*D3791-1\***

Wearpad

\*\*

ll 12/02/25

Location

Loc Qty

Loc Code

FP002

3

B110212

xl

106144

3

D3793-3

Manufactured No

230

Each

11.0000

1

1

**\*D3793-3\***

Wearplate Aft

\*\*

ll 12/02/25

Location

Loc Qty

Loc Code

FP001

11

B110066

xl

104212

11

MS21043-6

Purchased No

230

Each

268.0000

4

4

**\*MS21043-6\***

NUT

\*\*

ll 12/02/25

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

xl

D3794-1

Manufactured No

230

Each

13.0000

1

1

**\*D3794-1\***

Gasket Fwd

\*\*

ll 12/02/25

Location

Loc Qty

Loc Code

FP001

13

B110316

xl

104620

1

108497

5

109207

7

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased No

230

Each

45.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

ll 11/02/25

Location

Loc Qty

Loc Code

FP001

45

1127813

VO

m126988

45

D2741

Manufactured No

250

Each

39.0000

1

**\*D2741\***

Blade

\*\*

896414 14-2-26

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

NAS1515H3L

Purchased No

230

Each

54.0000

4

4

**\*NAS1515H3I \***

Washer

\*\*

ll 11/02/25

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

14

124542

14

NAS1611-013

Purchased No

230

Each

16.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

ll 11/02/25

Location

Loc Qty

Loc Code

FP001

16

1127813

VO

125445

16

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 535.0000 4 4

**\*AN3C6A\***

Bolt

\*\*

JL 12/20/13

LocationLoc QtyLoc Code

FG

10

122416

10

ST513

525

m125709

525

NAS1149C0832R Purchased No 230 Each 359.0000 1 1

**\*NAS1149C0832R\***

Washer

\*\*

JL 11/02/13

LocationLoc QtyLoc Code

ST292

359

122441

92

m114915

117

m125807

150

D3536-25 Manufactured No 230 Each 20.0000 1 1

**\*D3536-25\***

Gasket Center

\*\*

JL 11/02/13

LocationLoc QtyLoc Code

FG

6

87053

2

95328

4

FP001

14

109206

14

D3794-3 Manufactured No 230 Each 17.0000 1 1

**\*D3794-3\***

Gasket Aft

\*\*

JL 11/02/13

LocationLoc QtyLoc Code

FP001

17

108413

17

B110930

X1

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 164.0000 34 34

**\*AN3C5A\***

Bolt

\*\*

*ll 12/02/13*

Location

Loc Qty

Loc Code

FG

5

*11128057*

*v34*

122800

5

ST350

159

m127290

159

D3537-1

Manufactured No

230

Each

20.0000

3

3

**\*D3537-1\***

Wearpad

\*\*

*ll 12/02/13*

Location

Loc Qty

Loc Code

FG

18

*B110921*

*v1*

79833

8

88562

10

*B111594*

*v2*

FP001

2

108118

2

D3535-25

Manufactured No

230

Each

13.0000

1

1

**\*D3535-25\***

Wearplate Center

\*\*

*ll 12/02/13*

Location

Loc Qty

Loc Code

FG

2

*B110744*

*v1*

95077

2

FP002

11

106128

11

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

277.0000

8

8

**\*D3492-3\***

Plug

\*\*

ll 11/01/22

Location

Loc Qty

Loc Code

FP001

277

104853

72

107331

105

109800

100

NAS1149C0332R

Purchased

No

230

Each

9,547.000

38

38

**\*NAS1149C0332R\***

WASHER

\*\*

ll 11/01/22

Location

Loc Qty

Loc Code

GA

1277

125654

1277

st510

8270

m126319

2770

m127306

2500

m127410

3000

D3488-042

Manufactured

No

230

Each

9.0000

1

1

**\*D3488-042\***

Blade Fitting RH

\*\*

ll 11/01/25

Location

Loc Qty

Loc Code

FP001

9

106658

6

98887

3

B109911

xl

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

469.0000

38

38

**\*ALS4-1032-225\***

Rivnut

**\*\***

*HL 12/25*

Location

Loc Qty

Loc Code

FG

30

*M120179*

*x38*

M127028

30

ST280

10

M127028

10

st555

429

M127092

429

D3492-1

Manufactured

No

230

Each

195.0000

8

8

**\*D3492-1\***

Plug

**\*\***

*HL 12/27*

Location

Loc Qty

Loc Code

FP001

195

104844

195

*x8*

D3793-1

Manufactured

No

230

Each

6.0000

1

1

**\*D3793-1\***

Wearplate Fwd

**\*\***

*HL 12/25*

Location

Loc Qty

Loc Code

FP002

6

*B110121*

*x1*

109205

6

AN8C35A

Purchased

No

230

Each

75.0000

1

1

**\*AN8C35A\***

Bolt

**\*\***

*HL 12/25*

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

71

m126293

47

m127061

24

*x1*

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8	Purchased	No	230	Each	35.0000	1	1	
<b>*MS21083C8*</b>								**
Nut								ll 11/02/27

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D2745	Manufactured	No	ST319	35				
			m127255	35				
<b>*D2745*</b>								**
Bushing								ll 12/20/13

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
AN6C44A	Purchased	No	ST017	129	B110526			
			106847	5				
			107336	124				
<b>*AN6C44A*</b>								**
Bolt								ll 11/02/27

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
D3532-1	Manufactured	No	FG	2	11128319			
			103964	2				
			ST340	50				
			123900	50				
			ST341	4				
			m127300	4				
<b>*D3532-1*</b>								**
Spacer								14-2-26

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
DAS			ST054	86				
3			100519	26				
39			109803	60				

DAS  
31  
9-89

2X

DAS  
26  
9-89

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8	Purchased	No	250	Each	35.0000	2		DAS
<b>*MS21083C8*</b>								26
Nut								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
DAS			ST319	35				
6			m127255	35				
NAS1149D0863J 9-89	Purchased	No		250	Each	991.0000	2	DAS
<b>*NAS1149D0863J*</b>								26
Washer								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
DAS			FP001	6				
6			118078	6				
9-89			ST293	185				
			125484	185				
			ST510a	800				
			125268	600				
			125635	200				
D3493-1	Manufactured	No		250	Each	245.0000	2	DAS
<b>*D3493-1*</b>								26
Washer								9-89

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
DAS			FG	10				
6			97201	10				
9-89			ST051	235				
			105613	16				
			107916	60				
			109105	159				

\*\*\*ONLY INSTALL IF INSTALLING ON APICAL  
FLOAT SYSTEM\*\*\*

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Work Order ID: 110476

**\*110476\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

45.0000

2

2

**\*AN8C21A\***

Bolt

**\*\***

14-2-26

Location

Loc Qty

Loc Code

ST

2

123966

2

ST505

43

m127061

43

DAS

6

9-83

2X

DAS 31 9.83

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# **GENERAL NOTES:**

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

110476 MJS  
13-12-20

**RELEASED**  
2013-08-13

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE OSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

**DART AEROSPACE USA, INC.**

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

TITLE

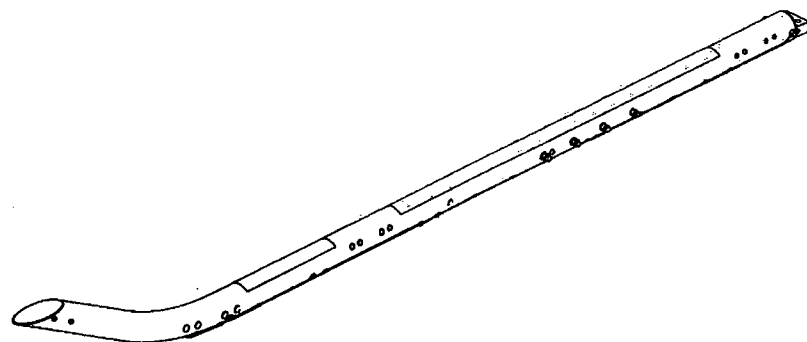
350 SKIDTUBE ASSEMBLY

SCALE

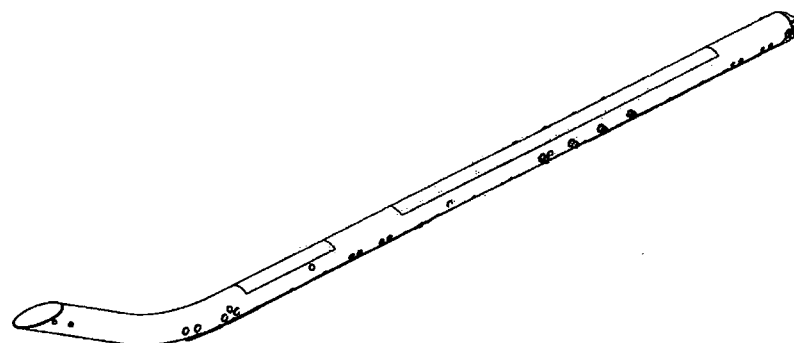
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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASED**  
2013-08-13  
*MD*

DESIGN	MM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	
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DE APPR.	<i>[Signature]</i>		
DATE	13.07.11		

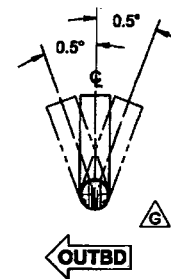
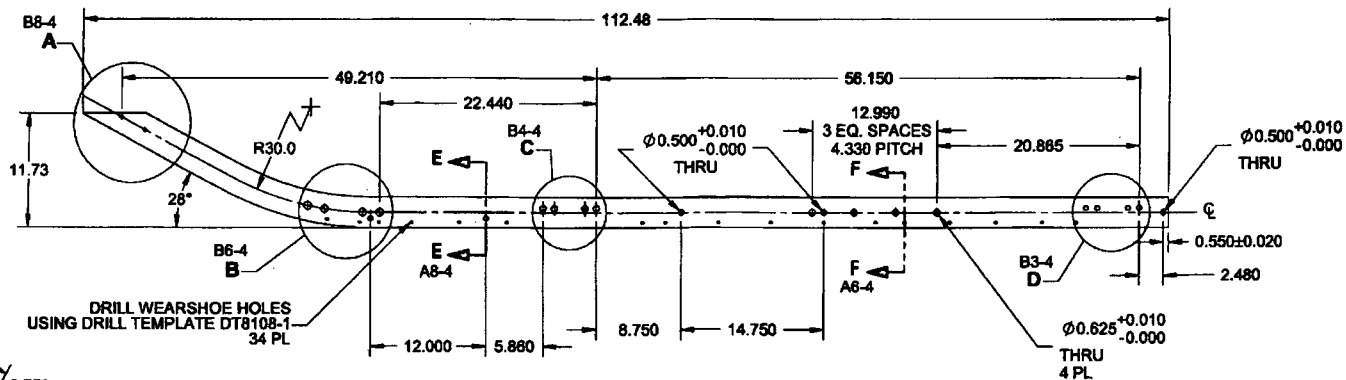
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**

**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

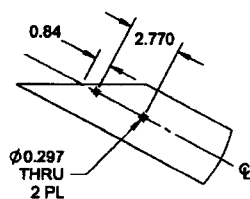
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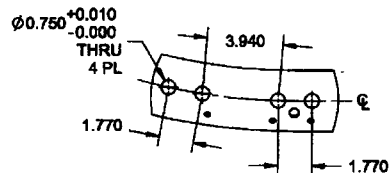
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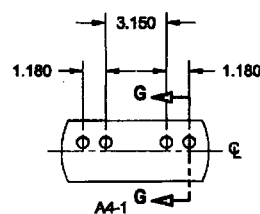
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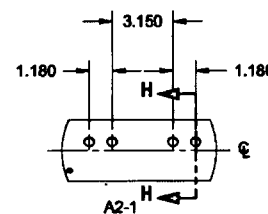
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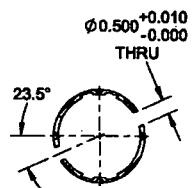
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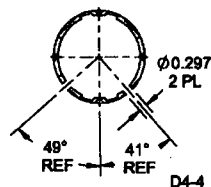
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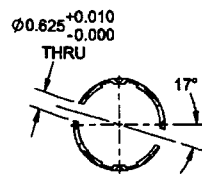
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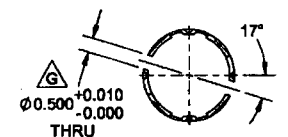
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL

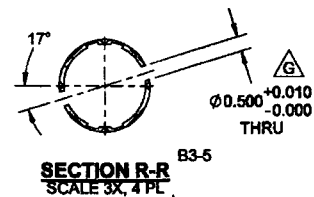
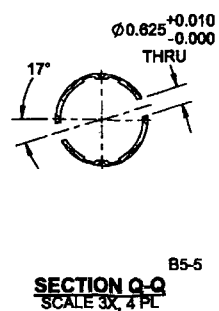
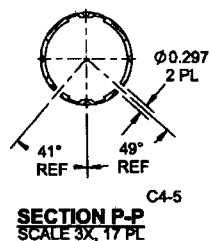
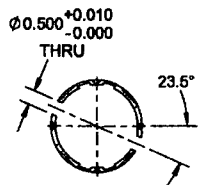
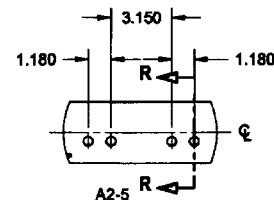
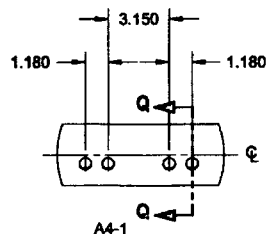
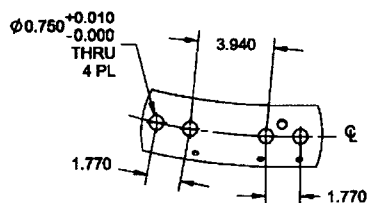
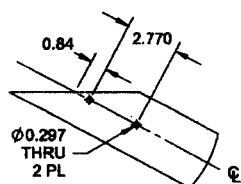
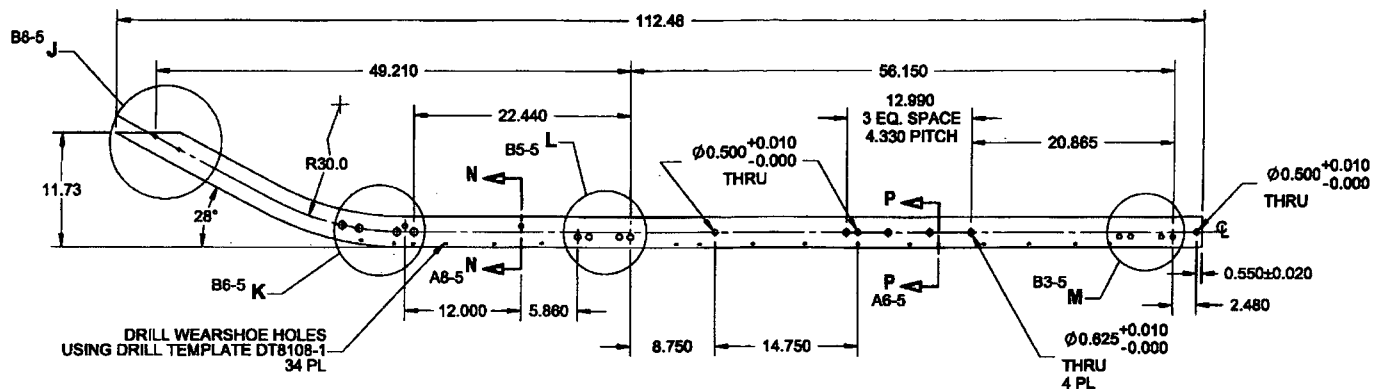


**SECTION H-H**  
SCALE 3X, 4 PL






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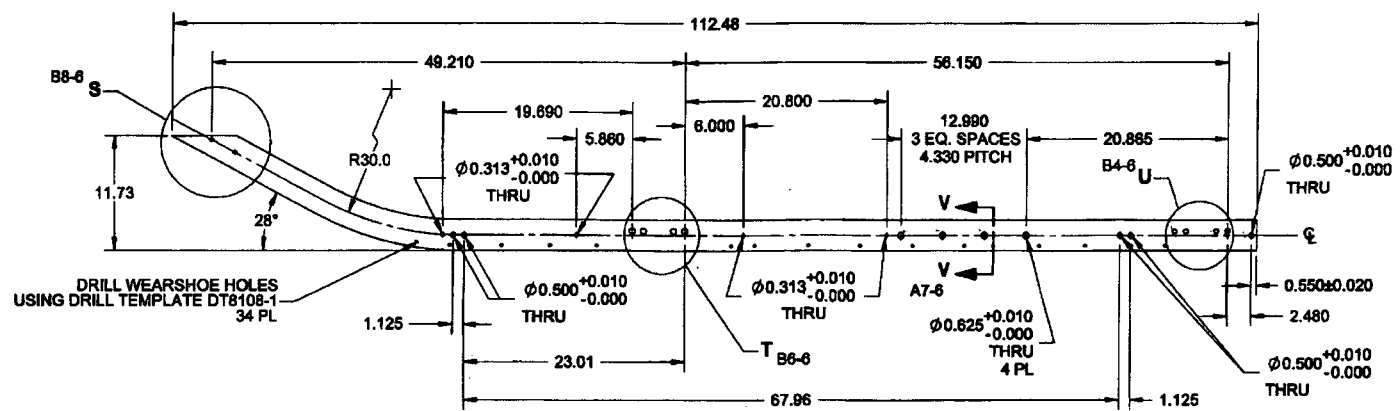
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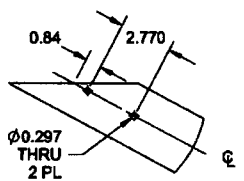
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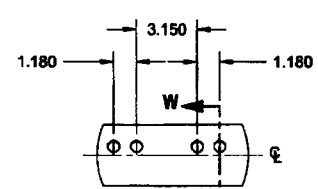
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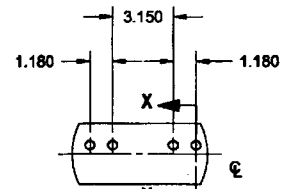
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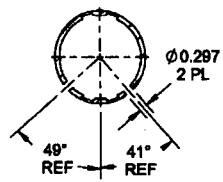
**DETAIL S**  
D8-6  
SCALE 2X



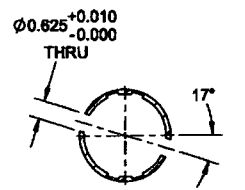
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C5-6  
SCALE 2X



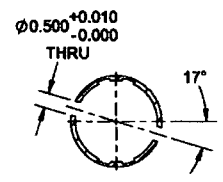
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL





**SECTION W-W**  
B8-6  
SCALE 3X, 4 PL

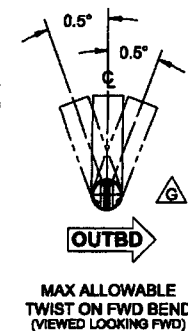
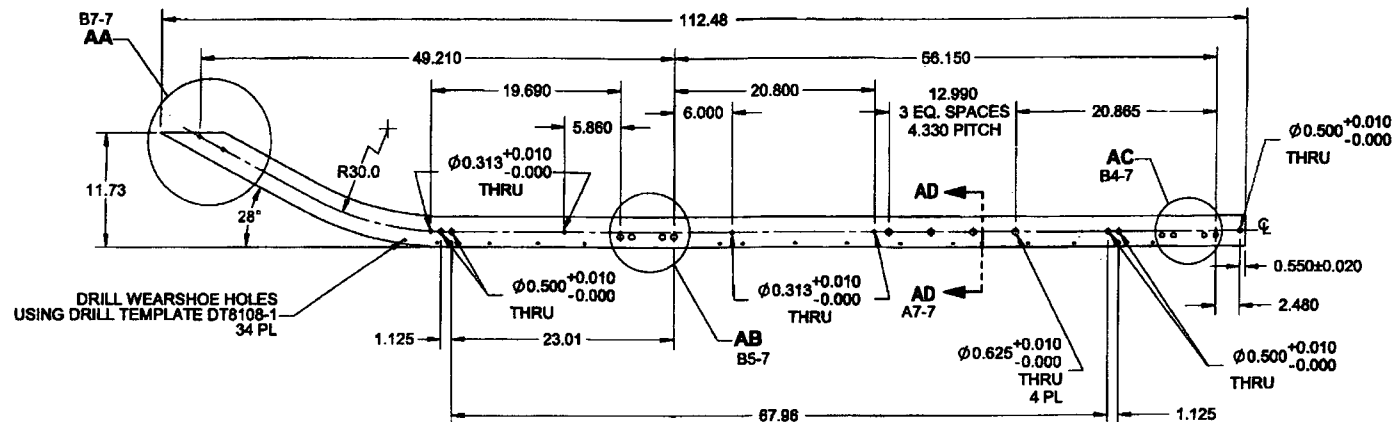


**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

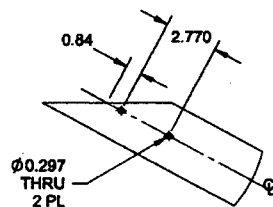
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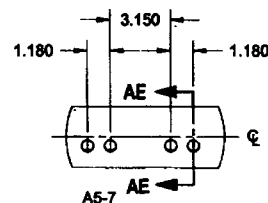
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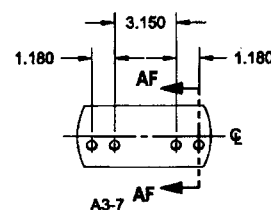
**D2750-4 RH SKIDTUBE**



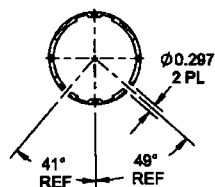
**DETAIL AA**  
SCALE 2X



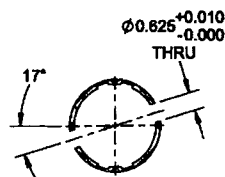
**DETAIL AB**  
SCALE 2X



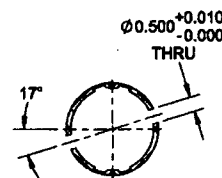
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



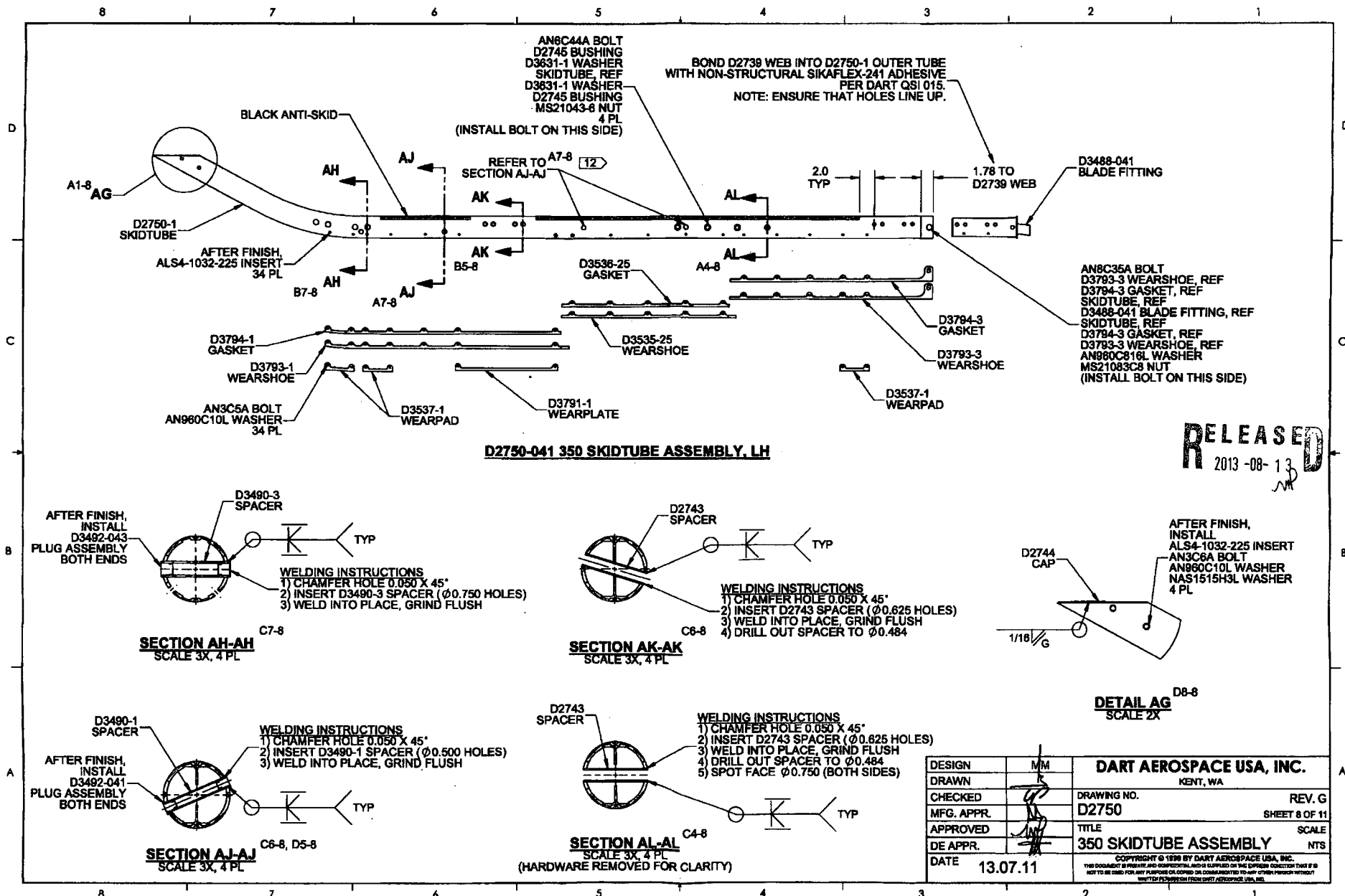
**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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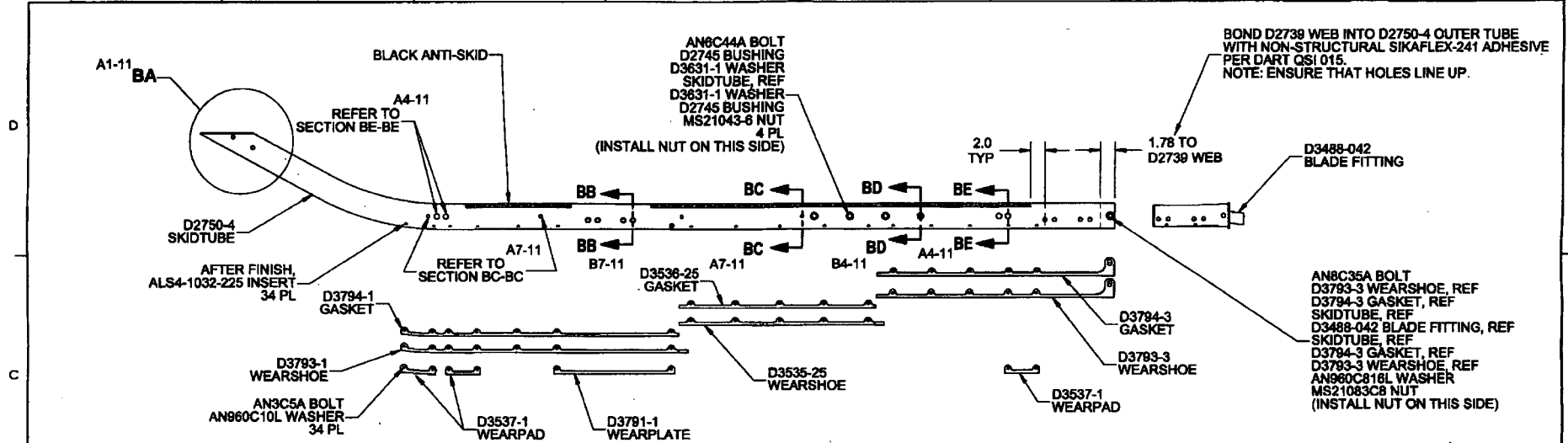






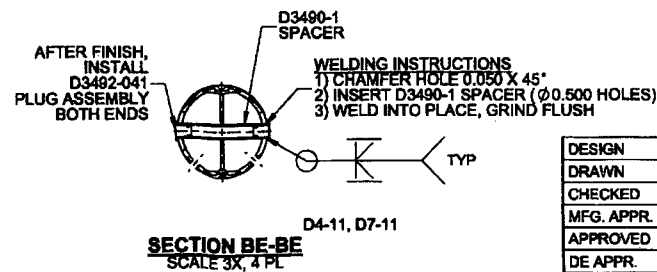
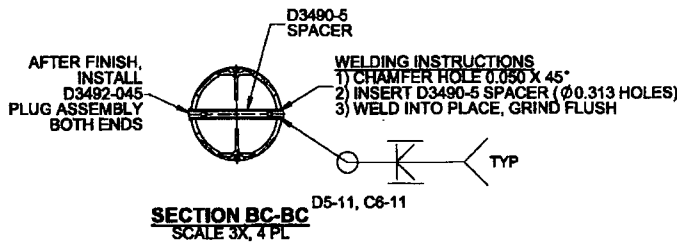
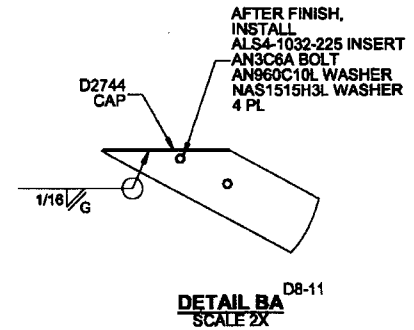
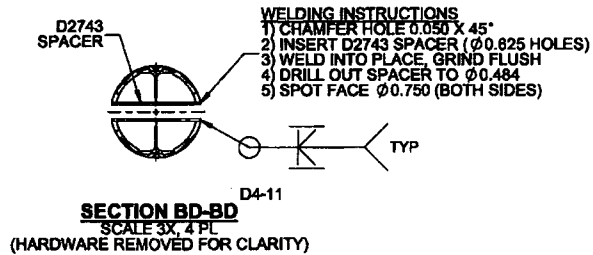
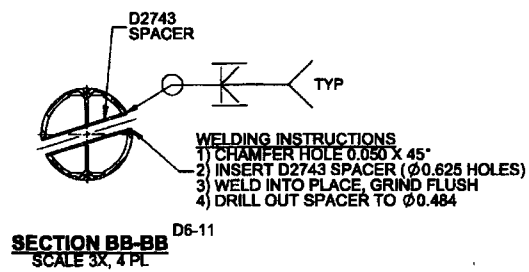


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**D2750-044 350 SKIDTUBE ASSEMBLY, RH**

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